

Date: Tuesday, 07/04/2009 11:08:49 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (EC 135)
Job Number	: 46605		
Estimate Number	: 10536		
P.O. Number	:	Part Number	: D135692011
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: D3049 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 19/03/2009 Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 42380	Material	:
Written By	: <i>[Signature]</i> 09.04.07	Due Date	: 31/03/2009 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:C 04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM Est Rev:D 08-04-16 Added Step 2 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*[Signature]* 09/04/15



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

*[Signature]* 09/04/15

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING

Program Batch Number

*[Signature]* 09.04.07.

3.0	MUHMWB10	UHMW 1" Black
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MAT NOT PULLED



Comment: Qty.: 5.6280 sf(s)/Unit Total: 11.2560 sf(s) X2

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black UHMW 1"(MUHMWB10)

Batch: 111354

IB 9-4-9

(4)

4.0	WATER JET	FLOW WATER JET
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IB 9-4-9



Comment: FLOW WATER JET

CUT BLANK AS PER FILE D3049\_BLANK

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

N.A 09/04/11

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Part Number: D135692011

Job Number:



Seq. #: Machine Or Operation: Description :

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 09/04/11

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 09/04/14 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.1000 f(s)/Unit Total : 4.2000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2182B060

(6.00")

Rubber Cushion

45405

SS 09/04/15 (x2)

10.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2274

Radius Block

44547

SS 09/04/15 (x2)

11.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2519

Clamp

43842

SS 09/04/15 (x2)

12.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 D2529

Washer

45388

SS 09/04/15 (x2)

## Process Sheet

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Job Number: 46605

Part Number: D135692011

Job Number:



Seq. #: Machine Or Operation: Description :

13.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

8 AN4-15A

Bolt

M 110399

14.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

8 AN960JD416

Washer

M 110363

15.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

8 MS21042L4

Nut (or -4)

M 1109282

16.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

2 D3049-1(ref)

Bearpaw

M 110180 x 5 M 111383 x 3

4 QS100M24S

Clamp

1 Paperwork package from Step 2(ref)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location: RWC

PPP Rev:

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 46605

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.04.15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 416005
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3049-1
<b>Inspection Dwg:</b> D3049	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	Ø0.260	✓			
B	0.93	+/-0.030	0.925	✓			
C	0.40	+0.030/-0.000	0.410	✓			
D	2.00	+/-0.030	1.998	✓			
E	10.250	+/-0.010	10.250	✓			
F	4.540	+/-0.030	4.540	✓			
G	5.88	+/-0.030	5.880	✓			
H	0.38	+/-0.030	0.380	✓			
I	11.50	+/-0.030	11.50	✓			
J	0.07 x 45°	+0.030/-0.010	0.060 x 45°	✓			
K	0.44 – 0.47	+/-0.000	0.450	✓			
L	R0.25	+/-0.030	R0.25	✓			
M	0.38	+/-0.010	0.375	✓			
N	0.95	+0.030/-0.010	0.950	✓			
O	0.69	+/-0.030	0.690	✓			
P	0.20	+/-0.030	0.200	✓			
Q	23.00	+/-0.030	23.00	✓			
R	0.25 x 45°	+/-0.030	0.250 x 45°	✓			

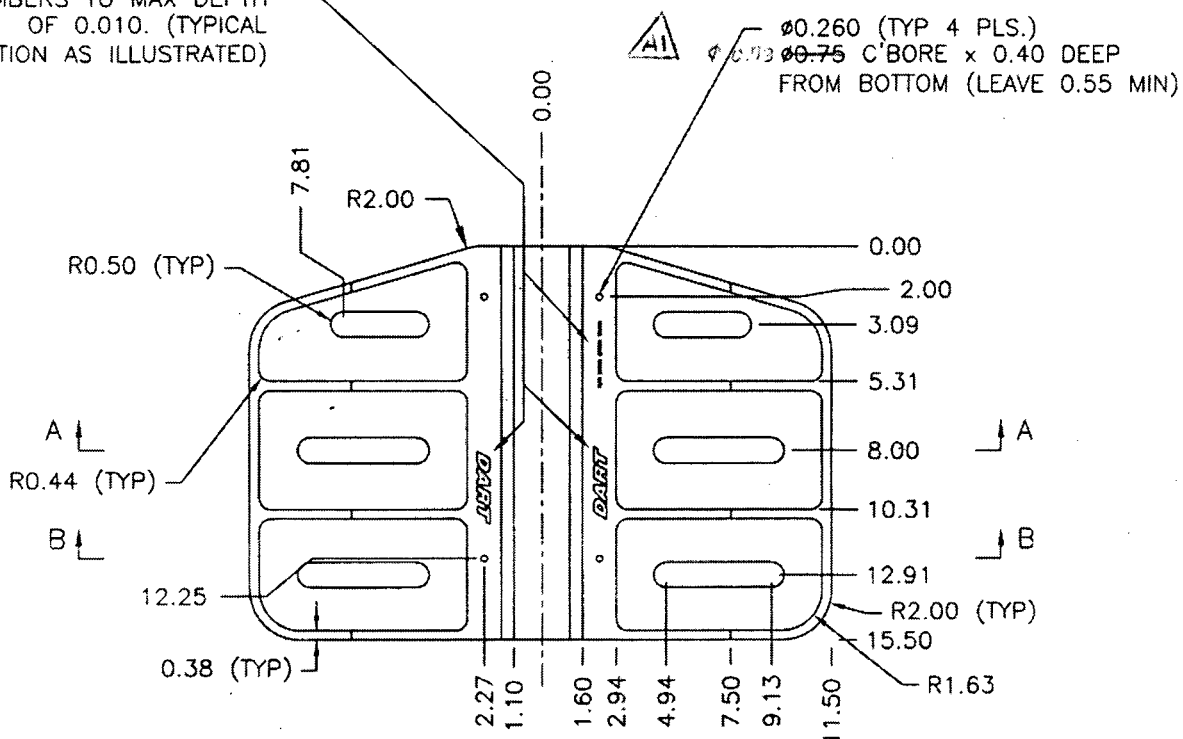
<b>Measured by:</b> M.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/04/11	<b>Date:</b> 09/04/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	



DESIGN KF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	[Signature] 03.01.13	[Signature] 03.01.13	

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL 1.00" THICK (MACHINE TO 0.950)

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WORK ORDER  
NO. 44605

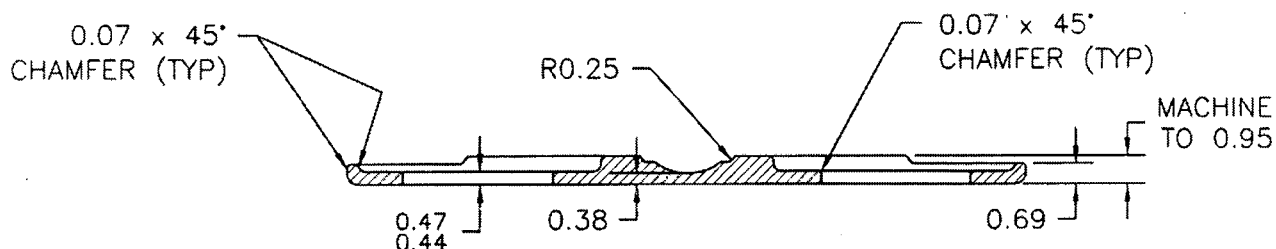
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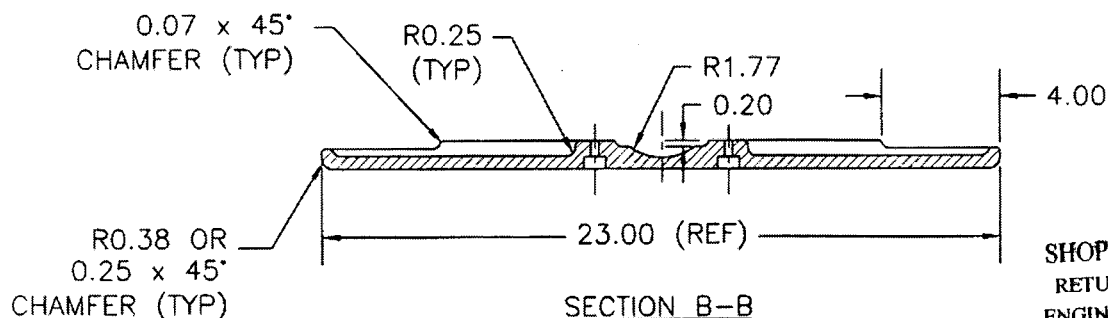


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED  
01.10.21 H



SECTION A-A



SECTION B-B

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